



Dart Hawkesbury
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D5951

Job Sheet 167647



Part No: D5951

Job Qty: 2 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/3/17

Job Tracking No:

Due Date: 11/5/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

DWG Rev B

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/4/17	0.00	0.00	Start Up Machining		SBL 17/11/11
100	CNC Vertical Machining	2 pcs		11/4/17	0.54	6.06	HAAS 1		SBL 17/11/11
110	QC	2 pcs		11/4/17	0.00	0.00	QC1		SBL 17/11/11
120	QC	2 pcs		11/4/17	0.00	0.00	QC8		FK 17-11-14
130	HandFinish	2 pcs		11/4/17	0.00	0.15	HandFinish1		2017-11-15 JH
140	Powdercoat	2 pcs		11/5/17	0.00	0.11	Powdercoat1		OK 17/11/15
150	QC	2 pcs		11/5/17	0.00	0.00	QC3		38
160	Packaging	2 pcs		11/5/17	0.00	0.00	Packaging3		SL 17/11/16
170	QC21-SA	2 Ea		11/5/17	0.00	0.00	QC21		17/11/16 JH

Part Op 100 - 1-Machine as per folio D5951, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble
Descriptions: 140 - START TIME: 10:15 00.11 300° FINISH: 10:45

11/13/14

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-013	2	12	0	0

Part Specifications

Specifications could not be found.

Plex 11/3/17 3:49 PM dart.Michaud-Febrille.Victoria

DART AEROSPACE LTD		Work Order: 167647
Description: Outer Fwd Saddle		Part Number: D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		438	438				
B	1.745	1.755		1,752	1,752				
C	5.245	5.255		5,252	5,252				
D	6.995	7.005		7,002	7,002				
E	5.240	5.260		5,250	5,250				
F	4.745	4.755		4,750	4,750				
G	0.315	0.322		316	316				
H	1.522	1.532		1,527	1,527				
I	3.048	3.058		3,053	3,053				
J	4.575	4.585		4,580	4,580				
K	0.315	0.322		316	316				
L	0.495	0.505		500	500				
M	0.490	0.510		503	503				
N	1.615	1.635		1,625	1,625				
O	7.990	8.010		8,000	8,000				
P	2.240	2.260		2,250	2,250				
Q	0.307	0.312		311	311				
R	0.760	0.765		762	762				
S	0.490	0.510		504	502				
T	1.375	1.395		1,375	1,380				
U	2.000	2.020		2,000	2,000				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBL, MK
Date: 17/11/11 17/11/13

Audited by: FK
Date: 17-11-14

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only

Work Order: <u>167647</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS		Completed By	
Part No. <u>D5951</u>		☐ Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved		☐ Skid-tube Machining ☒ Thermoforming ☐ Large Fab		☐ Cross tube Small Fab ☐ Finishing Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality Other	
NCR No. <u>19-7359</u>		Date: <u>17-11-14</u>		Step #: <u>100</u>		QTY Effective: <u>1</u>	
Description Work Order Deviation		Disposition		MRB (QS1042) Approval		19-8225 Approved	
Had to rework all chamfers (.075"x45) on all (H1H1) models that were ran by previous operator. The 2 other models went good but forgot to reload a different program for the D5951 with the X tube bore is smaller. Result is 2 big grooves .075" deep into .500 flange		Scrap a deskay and re-issue a w/o for 1 w/o # 15 : 168451 (for the re-issue)		Be 17-11-14 Lead hand / Supervisor Approval Verification 38 9-89 NOV 14 2017		QC / QA Coordinator Approval 38 9-89 NOV 14 2017	
Root Cause		FAULT CATEGORY					
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		No Re-verification ☒ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☒ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter		Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	
Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence		OTHER :					